

Reprint



Dart Aerospace Ltd.
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Canada

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D4273-042
Job Sheet 190467



Part No: D4273-042

Job Qty: 1 pcs

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/29/19		0.00	0.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
110	QC 9	1 pcs	3/29/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	APR 16 2019	DAS
							QC 9 - 43		24
							QC 9 - 50		9-89
120	QC 5	1	3/29/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	APR 16 2019	DAS
							QC 5 - 3		24
							QC 5 - 42		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S170551

Part: D4273-042

Job No: 190467

Serial No/Batch: S170551

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Date: 04/08/19

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
125 Handfinish - 2-1 Pressure- B4B	1 pcs	3/29/19	0.00 0.00		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	D.R 19/04/17
130 Powdercoat - 2 White Gl(S)- B4B	1 pcs	3/29/19	0.00 0.00		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
START: 10:45 O.V.T. 375° FINISH: 11:00.						
140 QC 3	1 pcs	3/29/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
150 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 -	
					Plex 2/19/19 1:52 PM dart.white.jess	

DAS
15
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
160 QC 21 - SA	1 pcs	3/29/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21 APR 22 2019
					QC 21 - SA - 53	

Part Op **100** - Weld per dwg A/R S.S. rod Batch: _____) - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN
 Descriptions: SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHER MESH IS INSTALL) weld as per dwg D4273
 using DT10317 2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O)
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel - 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
140 - QC3- Inspect Part Finish
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

009149

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5157434
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5163425
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5155103
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5168604
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5165737
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5166525
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5115309
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5155875
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5146907
D4277-19	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5115591
D4277-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5110971
D4277-5	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5163821
D4277-9	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5110979
D4278-041	Upper Rib Assembly-Hoop	1 pcs (1 ea)	100-Large Fab - Basket - 1	5170120
D4278-045	Rib Assembly, Fwd Cham	2 pcs (2 ea)	100-Large Fab - Basket - 1	5115916
D4278-047	Upper Rib Assembly-Straight	1 pcs (1 ea)	100-Large Fab - Basket - 1	5165039
D4279-5	End Mesh, Basket	1 pcs (1 ea)	100-Large Fab - Basket - 1	5117699
D4279-7	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5083614
D4279-9	End Mesh, Basket	1 pcs (1 ea)	100-Large Fab - Basket - 1	5083812
D4306-044	Rib Assembly, RH	1 pcs (1 ea)	100-Large Fab - Basket - 1	5062859
D4306-045	Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5163940
D4306-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5125615
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5160068
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5147379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	49	0
	D3913-1	1	5	0
	D3913-15	1	11	0
	D3913-3	1	9	0
	D3913-9	1	4	0
	D3916-5	3	6	0
	D4016-1	3	126	0
	D4017-7	3	13	0
	D4021-1	3	38	0
	D4277-19	1	5	0
	D4277-3	1	5	0
	D4277-5	2	0	0
	D4277-9	1	5	0
	D4278-041	1	0	0
	D4278-045	2	4	0
	D4278-047	1	1	0
	D4279-5	1	5	0
	D4279-7	2	4	0
	D4279-9	1	8	0
	D4306-044	1	2	0
	D4306-045	1	1	0
	D4306-1	1	5	0
	D4672-1	2	22	0
	M304EX0.75-16F	32	1,513	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Other/Details:					